

Date: Thursday, 5/11/2006 10:42:03 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARSHOE  
 Job Number : 27074  
 Estimate Number : 10314  
 P.O. Number : N/A Part Number : D265613  
 This Issue : 5/11/2006 S.O. No. : N/A Drawing Number : D2656 REV D  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : PURCHASED PARTS Drawing Revision : D  
 Previous Run : 25914 Material : N/A  
 Written By : SEE COMMENT Below Due Date : 5/30/2006 Qty: 50 Um: Each  
 Checked & Approved By : 06 05.11  
 Comment : Est: F 02.10.25 Re-format KJ/RF

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



## Comment: PURCHASING

Issue P/O: 1230

1-Email or ship DXF file to vendor

2-Laser Cut per Dwg D2656 flat pattern D2656-13

3-Material release note required

C266105/11 50

2.0 D265613F Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 50.0000 Each(s)

WEAR PLATE

3.0 PACKAGING 1 PACKAGING RESOURCE #1



## Comment: PACKAGING RESOURCE #1

Receive &amp; Inspect For Transit Damage

Ensure material release note is attached

R6/07/25 50

4.0 QC6 DIMENSIONAL CHECK



## Comment: DIMENSIONAL CHECK

Inspect dimensions per template D2656-13T1

06/05/29 50

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



## Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Deburr if necessary.

SB 06/04/01 50

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Thursday, 5/11/2006 10:42:03 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 27074

Part Number: D265613

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form on Brake as per Dwg D2656 using Jigs DT8261 and DT8326 *SAD 06:06:02 50*

2-Form joggle as per Dwg D2656 using Jig DT8158 Identify as D2656-13 *SA SAD 06:06:03 30*

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

*DL 06/06/21 (50)*

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*FL 06 06 22 (48)*

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: *FP21*

*FL 06 06 22 (48)*

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*DL 06/06/22 (48)*

Job Completion



*u 06.06.22*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
	7	Two Jaban Ser testing Project # 000000						

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

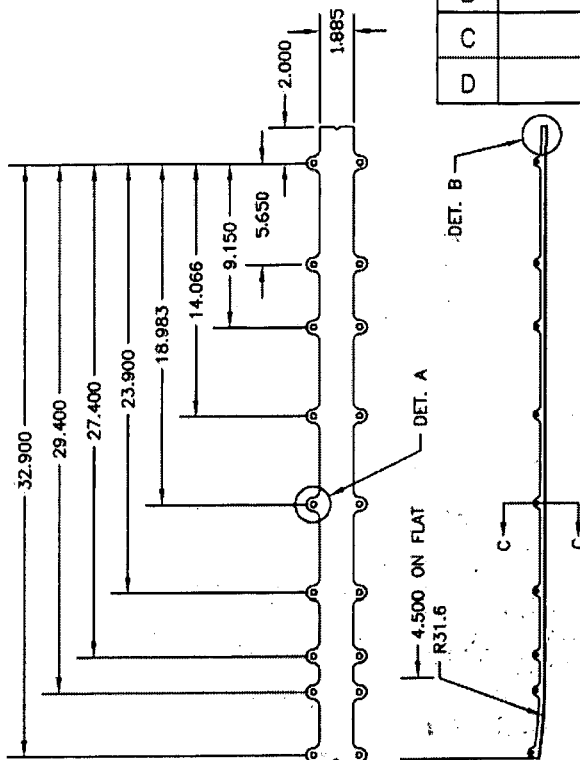
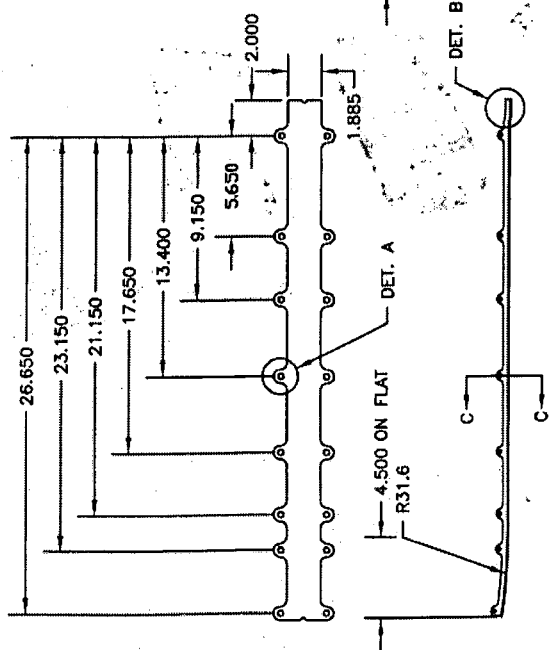
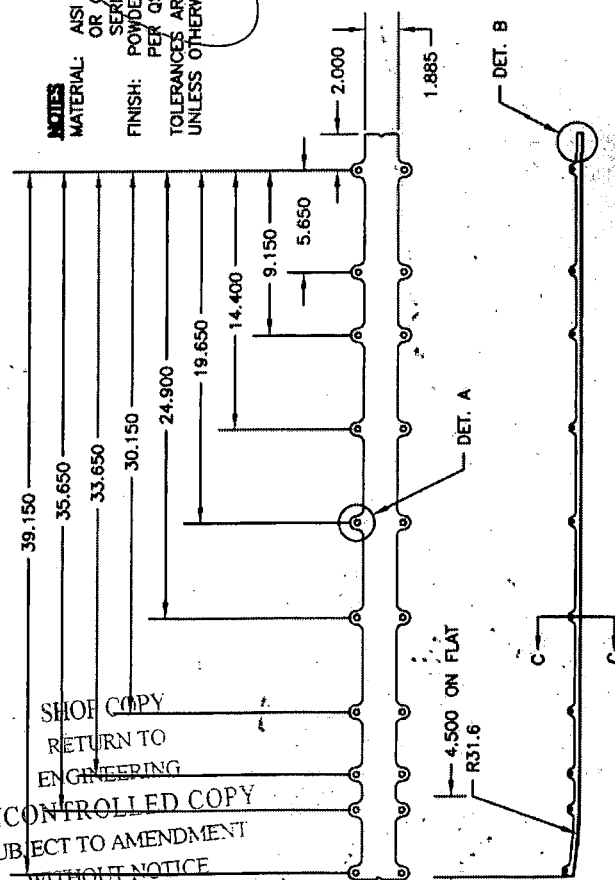
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_

NOTE: Date & initial all entries

NCR: Yes ☒ No ☐ DQA: DP Date: 06/06/22  
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

**DART**

DESIGN	DS	DRAWN BY	CP	DART AEROSPACE USA, INC.
				PORT HADLOCK, WA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2656
				REV. D SHEET 1 OF 4
DATE	05.08.17	TITLE	WEARSHOE	SCALE 1:10
A	97:03:25	NEW ISSUE		
B	97:06:02	CHANGED TABS		
C	97:06:26	R31.6 WAS R19.5		
D	05.08.17	ENLARGE ALL HOLES TO IMPROVE FIT		

**D2656-13****D2656-11****D2656-15**

**NOTES**  
MATERIAL: ASI 1010-1025 OR ASTM A36/A368/A1008  
OR CSA G40-21, 38W/44W/50W/60W/70W  
SERIES STEEL, 20 GAUGE (0.040 THICK)  
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6)  
TOLERANCES ARE PER DART QSI 0478  
UNLESS OTHERWISE NOTED

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05.09.06

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WORK ORDER  
NO. 27074

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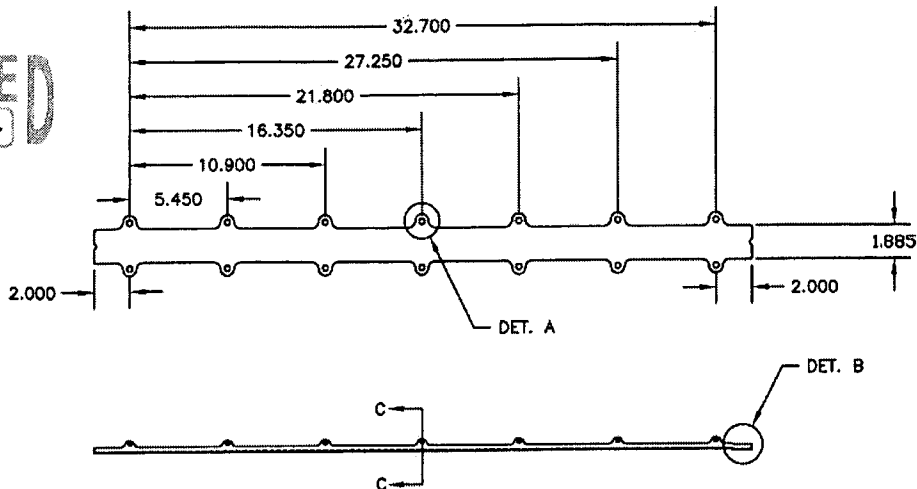
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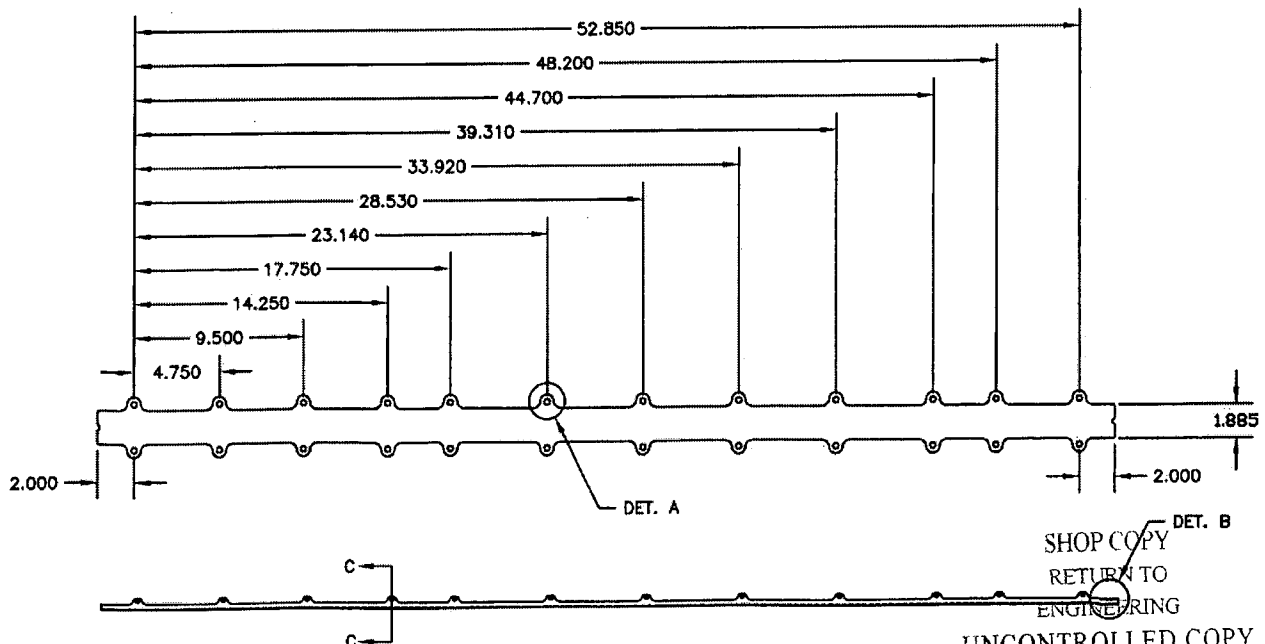
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DATE 05.08.17		TITLE WEARSHOE	SCALE 1:10

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DS 07.06 *[Signature]*

**D2656-21**



**D2856-23**



**NOTES**

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W  
SERIES STEEL, 20 GAUGE (0.040 THICK)  
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018  
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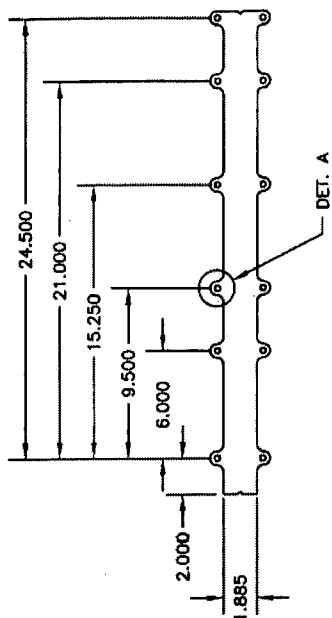
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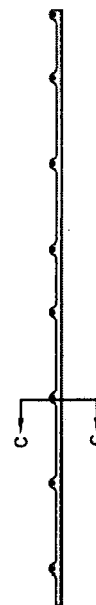
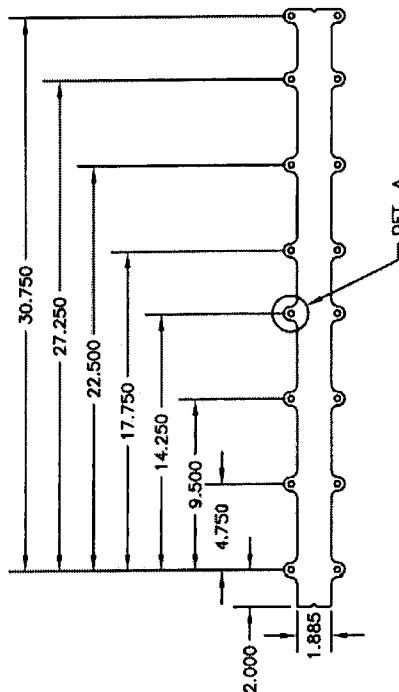


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DATE 05.08.17		TITLE WEARSHOE	SCALE 1:10

D2656-33

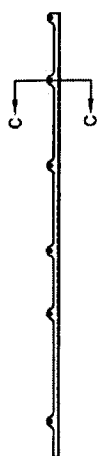
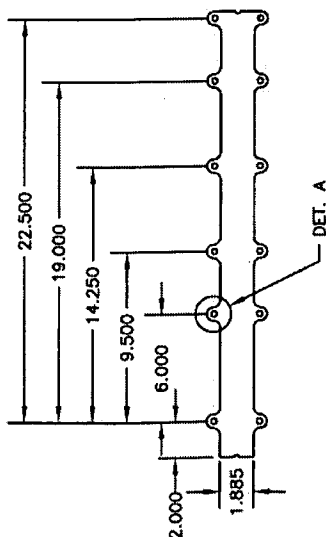


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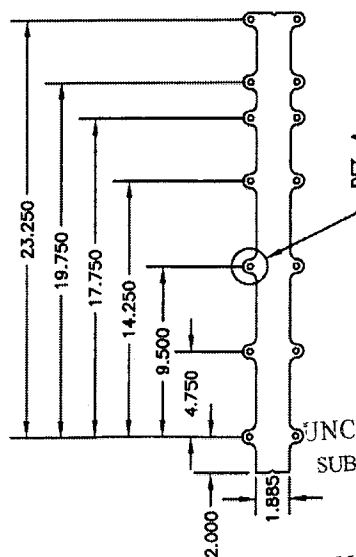


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D2658-31



D2658-35



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NOTES:  
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SERIES STEEL, 20 GAUGE (0.040 THICK)  
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED

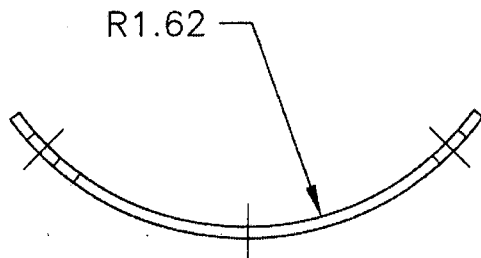
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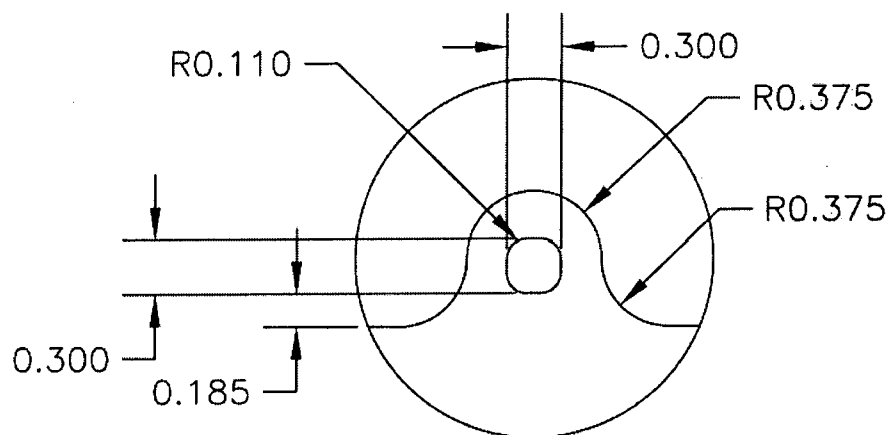
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DATE 05.08.17		TITLE WEARSHOE	SCALE 1:10

### SECTION C-C

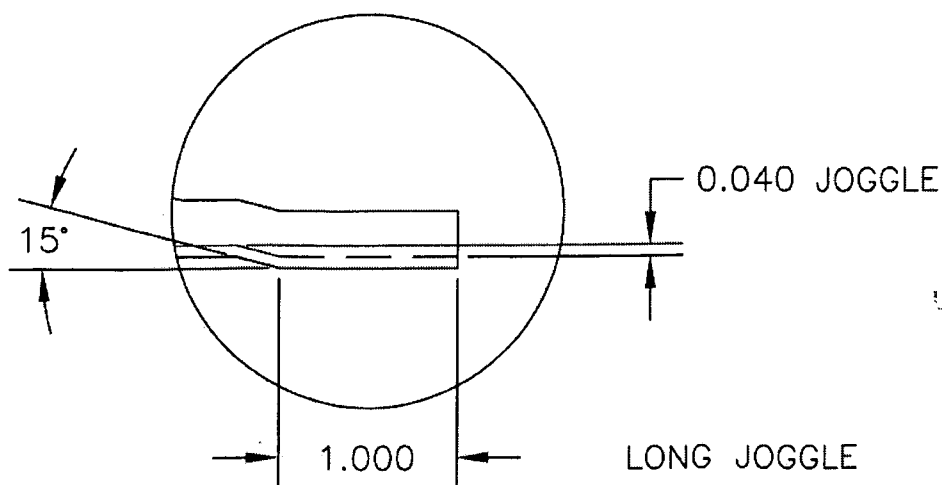


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### DETAIL A



### DETAIL B



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P.O.# 1230

20GA CRS.



New Zealand Steel Limited  
 Onehunga, South Auckland  
 P.O. Box 100, Auckland, New Zealand  
 Telephone: (09) 372 8888 / 372 8111 Auckland  
 (09) 372 8888 / 372 8111 Auckland  
 Fax: (09) 372 8888

## TEST CERTIFICATE

TOP 50372121

CUSTOMER	WORKING	P5050501002	SPECIFICATION	ASTMA1008 CS Type A	CERTIFICATE No	TC115838																
CUSTOMER ORN	90-2178-742		PRODUCT	CRA WIDE COIL	PAGE	1 of 1																
ROLL ORN	48968		DIMENSIONS	803" x 48" = Coil	DATE	03 August 2005																
PACK NUMBER	HEAT No	CHEMICAL COMPOSITION PERCENT														MECHANICAL TESTS (NEW SPECIFICATION - ASTM A1008)						
		C	SE	Mn	P	S	CU	NI	CR	MO	V	Nb	TI	AL	Si	FE	YIELD	TS	WELONG	WELONG	WELONG	LENGTH
		A1008														A1008						
R9-464117-00	644863	6	TR	24	7	17	15	23	14	3	3	3	3	3	3	3	Good				45	2415
R9-464118-00	644863	6	TR	24	7	17	15	23	14	3	3	3	3	3	3	3	Good				45	2554
R9-464119-00	779675	6	TR	24	7	17	15	23	14	3	3	3	3	3	3	3	Good				45	2638
R9-464200-00	779675	6	TR	24	7	17	15	23	14	3	3	3	3	3	3	3	Good				45	2825
R9-464211-00	779675	6	TR	24	7	17	15	23	14	3	3	3	3	3	3	3	Good				50	1923
R9-464212-00	779675	6	TR	24	7	17	15	23	14	3	3	3	3	3	3	3	Good				50	1978

YIELD	GAUGE LENGTH (G.L.)				PLASTIC STRAIN RATIO (R)				IMPACT TEST			CORROSION EQUIVALENT VALUE (CE)			
(A) 0.1% PROOF STRESS	(A) 200mm	(C) 50mm	(E) 2"	(G) 4"	(A) 0	(C) 0.05	(E) 0.05	(G) 0.05	(A) 10mm x 10mm	(C) 2.5mm x 10mm	(E) 2.5mm x 10mm	(A) C + Mn/5	(C) C + Mn/5	(E) C + Mn/5	(G) C + Mn/5
(B) LOWER YIELD STRESS	(B) 50mm	(D) 50mm	(F) 2"	(H) 4"	(B) 0	(D) 0.05	(F) 0.05	(H) 0.05	(B) 10mm x 10mm	(D) 2.5mm x 10mm	(F) 2.5mm x 10mm	(B) C + Mn/5	(D) C + Mn/5	(F) C + Mn/5	(H) C + Mn/5

WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED  
 WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED

CO-METALLURGIST

